

### Abstract

A method of potting a plurality of hollow fiber membranes into a mass of solidified potting liquid is described. Open ends of a plurality of hollow fiber membranes are enclosed in a first material held in a container which may be a part of a permeate collection means, for example, a permeate pan or header enclosure. A potting liquid is flowed into the container over the first material. The potting liquid surrounds each hollow fiber membrane and then becomes a solid mass that provides a fluid-tight seal to the outside of the hollow fiber membranes. The first material prevents the potting liquid or solid mass from closing the ends of the membranes. The first material is later removed from the ends of the hollow fiber membranes.